

Work Order ID 95507

Thursday, January 10, 2013 10:24:12 AM

95507

Page 1

Item ID: D3208-11

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Filler

Stop *NS2*

Start Date: 1/10/2013 Start Qty: 12.00

12

Cust Item ID:

Required Date: 1/11/2013 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

WVF

Date:

13-1-10

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3208

C

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3208

Dwg Rev: C

6061 .063"

Prog Rev: C

2-Deburr if necessary

12 0 Jm 13-1-10

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

12 0 Jm 13-1-10

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Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

DAS
15
2-89
13-1-10

12

130

Chemical Conversion Coat per QSI005 4.1

0.00

130

HandFinish

Memo

0.00

Hand Finishing

12 766 13-1-11

140

QC7-Inspect Chemical Conversion Coat

0.00

140

QC

Memo

0.00

Quality Control

DAS
15
2-89
13-1-11

12

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Identify as per dwg & Stock Location:

5+
203

0.00

150

Packaging

Memo

0.00

Packaging

13/11/11 (12)

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

13/11/14

MF

13-1-11

Picklist Print

Thursday, January 10, 2013 10:24:11 AM

Page 1

Work Order ID: 95507

Parent Item: D3208-11

Parent Item Name: Filler

Start Date: 1/10/2013

Required Date: 1/11/2013

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: A04.06.09New issueKJ/RF
IPP B 08.11.17 Waterjet EC verified: DD IPP REV C:PER REV B 12-03-23
JLM VERIFIED BY:EC IPP REV:D 12.04.20 as per dwg rev.C DD verf:EC



Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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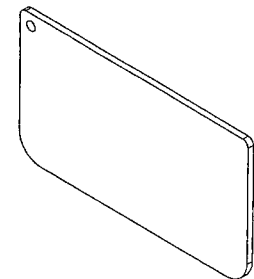
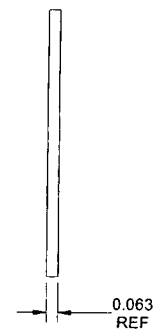
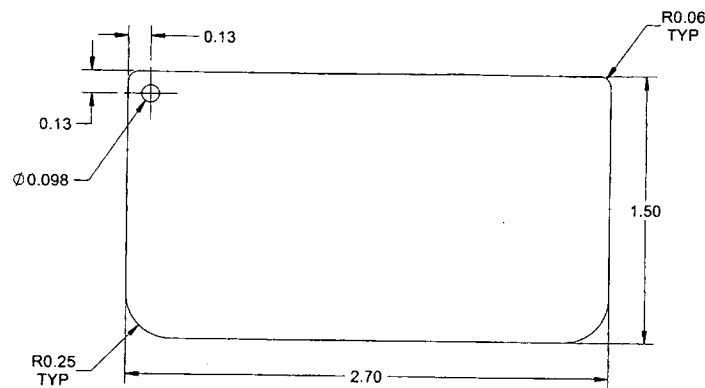
M6061T6S.063 6061-T6 .063 Sheet		Purchased	No			100	sf	342.5625	0.1646	20791579 2.1			Jm 13-1-10
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT021		342.5625							
				123135		126.5625				123135			
				124003		216							

AL

~~DAS~~

15
9-89

by	Approved
	



D3208-11 FILLER

95507

RELEASED
2012-04-18
W

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.02 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D3208	SHEET 9 OF 9
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	DOUBLER	NTS
DATE	12.04.12	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	